

Date: Saturday, 11/5/2005 12:56:58 PM  
 User: Linda Lacelle

## Process Sheet

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Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 BASKET BASE (SHORT)  
 Job Number : 23714A  
 Estimate Number : 10209  
 P.O. Number : N/A Part Number : D3265041  
 This Issue : 11/5/2005 S.O. No. : N/A Drawing Number : D3265 REV B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B  
 Previous Run : N/A Material :  
 Written By : SEE COMMENT BELOW Due Date : 11/30/2005 Qty: 1 Um: Each  
 Checked & Approved By : SEE ABOVE USER & DATE  
 Comment : Est Rev:C Re-Format 05-11-03 JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop B26259 AA 06/04/04
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W M100560 AA 06/04/04
3.0	D22323	Basket Hinge B25239 AA 06/04/04
4.0	D2325	Support Gusset (350 Bask B25687 AA 06/04/04
5.0	D23273	Spacer Bushing B25823 AA 06/04/04
6.0	D2581	Mounting Bracket B25834 AA 06/04/04
7.0	D34425	Shim B24246 AA 06/04/04
8.0	M304EX07516F	Expanded Metal Flat Stai M10058 AA 06/04/04
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

AA 06/04/04

10.0

QC9/6

DDIMENSIONAL &amp; WELDING INSPECTION



Comment: DDIMENSIONAL &amp; WELDING INSPECTION

AA 06-04-07

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/11 (1)

Date: Saturday, 11/5/2005 12:56:59 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 23714A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with White Sikaflex-291

Batch: 4100480

Expiry date: 11/2006

JAD 06104205 (1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20604.17  
level 21 inspection 20604/18 (1)

Job Completion



u 0604.18

5/30

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23714
<b>Description:</b> 350 Basket Base (Short)	<b>Part Number:</b>	D3265-041
<b>Dwg:</b> D3265 Rev. A; D2235 Rev. B1	<b>Qty:</b>	
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																								
1	DC	Issue Traveler <b>Dwg not required</b>	JJ	05.06.30	1																								
2	WS	Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing. (M304TS0.750W.065) Batch: _____ Cut Qty <del>4</del> 3 D2235-1 from: _____ Qty <del>4</del> 3 D3166-1 Batch: _____																											
3	WS	Drill hole in D3265-3 as per Dwg D3265																											
4	WS	Deburr																											
5A	WS	<b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2232-3</td> <td>Hinge bracket</td> <td>_____</td> </tr> <tr> <td>4</td> <td>D2325</td> <td>Support Gusset</td> <td>_____</td> </tr> <tr> <td>2</td> <td>D2327-3</td> <td>Bushing</td> <td>_____</td> </tr> <tr> <td>2</td> <td>D2581</td> <td>Mounting Bracket</td> <td>_____</td> </tr> <tr> <td>26sf</td> <td>M304EX0.75-16F</td> <td>Expanded Metal</td> <td>_____</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D2232-3	Hinge bracket	_____	4	D2325	Support Gusset	_____	2	D2327-3	Bushing	_____	2	D2581	Mounting Bracket	_____	26sf	M304EX0.75-16F	Expanded Metal	_____			
Qty	Part Number	Description	Batch																										
2	D2232-3	Hinge bracket	_____																										
4	D2325	Support Gusset	_____																										
2	D2327-3	Bushing	_____																										
2	D2581	Mounting Bracket	_____																										
26sf	M304EX0.75-16F	Expanded Metal	_____																										
5B	WS	<i>REMOVE ALL MARKINGS FROM MATERIAL</i>																											
6	WS	Weld as per Dwg D3265 using Welding Table and corner Jig <b>Deburr as required</b>																											
7	QC9/6	Inspect Welding and Dimensions																											
8	WS	Take Traveller D350-607-04X to KP																											
9	FP	Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3																											
10	QC3	Inspect Powder Coat																											
11	FP	Seal support gusset seam with White Sikaflex-291 Batch: _____ Expiry date: _____																											
12	QC5	Inspect work to Step 11																											
13	FP	To GA Cell for Assembly																											

Rev	Date	Change	Revised By	Approved
A	04.02.02	New issue	KJ/DS	JJ

**RELEASED**  
04.02.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23714
<b>Description:</b> 350 Basket Lid (Short)		<b>Part Number:</b>	D3266-041
<b>Dwg:</b> D3266 Rev. A / D2236 Rev. B1		<b>Qty:</b>	1
Page 1 of 1			

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Dwg not required</b>	AS	05.06.30	1
2	WS	Cut 3/4" x 3/4" square tubing as per Dwg D3266 Material: 304/316 SS tube .063" wall (M304TS0.750W.065) Batch: _____ Cut Qty 4 D2236 from: Batch: _____ Qty 1 D3166-3 Batch: _____			
3	WS	Drill holes in D3266-1 as per Dwg D3266 using Drill Jig DT8305			
4	WS	Deburr			
5A	WS	<b>Pick:</b> Qty Part Number Description Batch 2 D2232-1 Hinge plate _____ 2 D2327-1 Bushing _____ 1 D2506 Label Plate _____ 2 D2581 Mounting Bracket _____ 10sf M304EX0.75-16F Expanded Metal _____			
5B	WS	<i>Remove all Markings from Material</i>			
6	WS	Weld as per Dwg D3266 using Welding Table and corner Jig <b>Deburr as required</b>			
7	QC6 & 9	Inspect Welding and Dimensions			
8	FP	Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3			
9	FP	Wing Walk and Spray Paint black as per Dwg D3266 and QSI 005 4.4 Batch: _____ Batch: _____			
10	QC3	Inspect Powder Coat and Wing Walk			
11	FP	To GA Cell for Assembly			

Rev	Date	Change	Revised By	Approved
A	04.02.02	New issue	KJ/DS	AS

**RELEASED**  
04.02.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/04/18

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_